



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3319-3
Job Sheet 186311



Part No: D3319-3

Job Qty: 10 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/21/18	0.00	4.67	Waterjet - Flow		
110	QC	20 pcs		11/21/18	0.00	0.00	QC2 Waterjet-2		
120	QC	20 pcs		11/21/18	0.00	0.00	QC8-2		
140	Brake NC	10 pcs		11/21/18	0.12	0.70	Brake NC 1		
150	QC	10 pcs		11/21/18	0.00	0.00	QC5		
160	Autoweld 1	10 pcs		11/21/18	0.00	3.19	Automated welding		
170	QC	10 pcs		11/21/18	0.00	0.00	QC10		
180	QC	10 pcs		11/21/18	0.00	0.00	QC5		
190	SprayPaint	10 pcs		11/21/18	0.00	1.00	Spray Paint		
200	QC	10 pcs		11/21/18	0.00	0.00	QC3		
210	Packaging	10 pcs		11/21/18	0.00	0.00	Packaging3-1		
220	QC21-SA	10 Ea		11/21/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod 138901

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 138978 EX 11/19

210 - Identify on inside surface using a permanent fine point marker with the following:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	56 sf (2.8 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	56	313	0

28
100 1 135

30 31 75



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ASAP

D3319-3
Job Sheet 186311



Part No: D3319-3

Job Qty: 20 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV:D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		11/21/18	0.00	2.34	Waterjet - Flow		OK 18/11/14
110	QC	10 pcs		11/21/18	0.00	0.00	QC2 Waterjet-2		OK 18/11/14 DAS
120	QC	10 pcs		11/21/18	0.00	0.00	QC8-2		NOV 19 2018 68
140	Brake NC	20 pcs		11/21/18	0.12	1.40	Brake NC 1		DAS 9-89
150	QC	20 pcs		11/21/18	0.00	0.00	QC5		38
160	Autoweld 1	20 pcs		11/21/18	0.00	6.37	Automated welding		9-88
170	QC	20 pcs		11/21/18	0.00	0.00	QC10		
180	QC	20 pcs		11/21/18	0.00	0.00	QC5		
190	SprayPaint	20 pcs		11/21/18	0.00	2.00	Spray Paint		
200	QC	20 pcs		11/21/18	0.00	0.00	QC3		
210	Packaging	20 pcs		11/21/18	0.00	0.00	Packaging3-1		
220	QC21-SA	20 Ea		11/21/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Debur if necessary
Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: _____

210 - Identify on inside surface using a permanent fine point marker with the following:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	32.5000 sf (3.25 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	33	301	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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2	Wearplate	0.500inches + 0.005 - 0.001	0.506 0.499
3	Wearplate	0.316inches ± 0.010	0.326 0.306
4	Wearplate	0.607inches ± 0.010	0.617 0.597
5	Wearplate	2.940inches ± 0.030	2.970 2.910
6	Wearplate	2.690inches ± 0.030	2.720 2.660
7	Wearplate	3.527inches ± 0.010	3.537 3.517
8	Wearplate	4.520inches ± 0.030	4.550 4.490
9	Wearplate	5.063inches ± 0.010	5.073 5.053
10	Wearplate	6.160inches ± 0.030	6.190 6.130
11	Wearplate	0.600inches ± 0.030	0.630 0.570
12	Wearplate	8.690inches ± 0.010	8.700 8.680
13	Wearplate	30.790inches ± 0.010	30.800 30.780
14	Wearplate	52.880inches ± 0.030	52.910 52.850
15	Wearplate	62.770inches ± 0.010	62.780 62.760
16	Wearplate	74.420inches ± 0.010	74.430 74.410
17	Wearplate	75.520inches ± 0.030	75.550 75.490
18	Wearplate	0.050inches ± 0.010	0.060 0.040

Plex 11/14/18 8:50 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: **S127971**



Full Length Wearplate

PART NO: **D3319-3**
 Serial No/Batch: **S127971**
 Revision:
 Operation:
 Change No:

Waterjet —

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 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Flow — 11/14/18
 Job No: 186311

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor Approval Verification
				QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
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Past Expiry Date	☐	Manufacturing Process	☐								
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